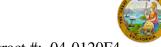
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-011917 Address: 333 Burma Road **Date Inspected:** 18-Jan-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Mr. An qing xiang/ Mr. Li lin No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

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1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 042218 perform FCAW welding on, Skin E fit lugs inside East tower, Lift 4, weld joint identified as ESTL4-2 B/L-45, 46. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049220 perform FCAW welding on, Skin E fit lugs inside East tower, Lift 4, weld joint identified as ESTL4-2 G/L-119. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040699/ 044550 perform SAW welding on, CD corner of East tower, Lift 5, weld joint identified as ESD1-TL5- 2B/F-16B. ZPMC CWI Identified as Mr. An qing xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U2B-S.

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WELDING INSPECTION REPORT

(Continued Page 2 of 2)

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053469 perform SMAW tack welding on, AE corner of North tower, Lift 5, weld joint identified as NSD1-TL5- 3B/F-39B. ZPMC CWI Identified as Mr. Liu yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3314.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040269 perform SMAW repair welding on, CD corner of North tower, Lift 4, weld joint identified as NSTL4- 3B/L-1 A/B. ZPMC CWI Identified as Mr. Liu zhong an. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)- repair.

6. This QA inspector, Baskar Govindarajan, taken measurements of Flange to flange distance, stiffener to stiffener distance, Bolt hole requirement, 10 mm to CJP distance of 4 struts which is as follows, 1. WD1-A305-77mtr.-4, 2. WD1-A 305-53mtr.-4, 3. WD1-A 305-53 mtr.-3, 4. WD1-A305-65mtr. -3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer